

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010022**Date Inspected:** 22-Oct-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard
Segment 5AE

This QA Inspector observed drilling of bolt holes in progress on the Deck Plate at panel points 29 thru 30, bike path side.

Segment 5BW/5CW

This QA Inspector observed grinding the weld reinforcement flush on the CJP Side Plate Segment splice, cross beam side.

Segment L5E

This QA Inspector observed the alignment of Lift 5E with CB4 after reposition of segments.

Segment 5AE/5BE

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This QA Inspector observed ABF personnel performing Magnetic Particle Testing (MT) of the cross beam side Edge Plate and Side Plate after previously found indications were removed by grinding at the locations of removed fit up plates.

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of the cross beam side Edge Plate and Side Plate segment splices, D scan was being performed.

Segment 1AW

This QA Inspector observed ZPMC personnel performing MT of cope holes at panel point 8.5 at the FL2 floor beam to Bottom Plate connection.

Segment 5BE

This QA Inspector observed Heat straightening in progress of the Longitudinal Diaphragm flange at panel points 34 to 35, cross beam side. HSR1 (B)-7753 was being followed for this procedure.

Segment 2AE/2BE

This QA Inspector observed carbon air arc gouging in progress for excavation of UT rejects in the Bottom Plate CJP segment splice at the following Y locations 80mm thru 2780mm, 3460mm thru 6960mm and 7182mm thru 7352mm from the Bike Path side edge of the Bottom Plate.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
